

Ship 12/21/2016

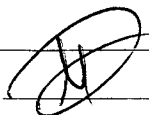
Work Order ID 139941

139941

Page 1

Monday, December 14, 2015 3:57:54 PM

Item ID: D2610-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, EC120 Step
 Start Date: 12/14/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/18/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 12.12.14 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2610	Rev E								
D2678	REV B								

100 0.00
 100 Large Fab
 Large Fab Memo 0.00
 Large Fab Deburr both ends and bevel aft end for welding
 Drill top holes using Drill Jig DT 8171
 Open as per Dwg D2678
 Deburr holes
 Mill cutout on sheet 3 of Dwg D2678 using Jig DT 8173 as a stopper S.C.-L. 12/12/15
 Drill bottom holes using Drill Jig DT 8172 and DT 8195
 Open holes as per dwg

1 DEC 17 2015 DAS 24 9-00

Work Order ID 139941

139941

Page 2

Monday, December 14, 2015 3:57:54 PM

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Start Date: 12/14/2015 Start Qty: 1.00 *1*

Required Date: 12/18/2015 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00				1x	DAS 43 9-89		DEC 17 2015
Quality Control									

120	Weld per dwg A/R Aluminum rod Batch: 131562	0.00							
120	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld lugs. Use face of cutout as shown on Dwg.								
	Use D2678 to locate D2613, forward face of lug, using DT 8211 A.								
	Locate 2nd D2613 Lug off 1st using DT 8072								
	Weld D2734 end cap								
	Grind end cap welds flush								

DEC 17 2015 DAS 24 9-89

Monday, December 14, 2015 3:57:54 PM

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/14/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/18/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

**Insp.
Stamp**

0.00

155

QC

Memo

0.00

Quality Control

0.00

160

Large Fab

Large Fab

Large Fab

Memo

0.00

Inspect for foreign object per QSI 024
Install end plate D2683-041.
Position with location jig DT8071
Transfer drill 0.098 holes into D2683-041

Open holes to 0.128
Remove D2683-041

Deburr

Countersink .128 holes to .218 X100°

Touch up holes with alodine Assemble as per dwg

1 DEC 17 2015 43 9-89

DEC 18 2015

Work Order ID 139941

Monday, December 14, 2015 3:57:55 PM

139941

Page 5

Item ID: D2610-042 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/18/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>PH</u>			16 9-89 12/18
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <u>M 130746</u> Memo START TIME: <u>8:55</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>9:05</u>	0.00 0.00							<u>1</u> <u>φ</u> <u>15-12-21</u> <u>DS</u> <u>34</u> <u>989</u>
190 *190* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>101133570</u> Large Fab Memo	0.00							<u>1x</u> <u>φ</u> <u>all</u> <u>12/26/1</u>

Work Order ID 139941***139941***

Page 6

Monday, December 14, 2015 3:57:55 PM

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Required Date: 12/18/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							DAS 9 9-89
200									
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location: _____	0.00							DAS 28 9-89
210									
Packaging	Memo	0.00							
Packaging									DEC 21 2015
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									DEC 22 2015

20151221

Picklist Print

Page 1

Monday, December 14, 2015 3:57:58 PM

Work Order ID: 139941

139941

Parent Item: D2610-042

D2610-042

Parent Item Name: Step, EC120 Step

Start Date: 12/14/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP H00.07.20Added inspection for QSI 024EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2669-45

Manufactured

No

Each

3.0000

1

D2669-45

End Plate

**

DEC 17 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

3

137402

3

B140020 → 1

D2613

Manufactured

No

100

Each

186.0000

2

2

D2613

Lug, Ec 120 Step

**

MLJ 15-12-16

Location

Loc Qty

Loc Code

Mezz

8

139727

8

15005

178

2

D2674-3

Manufactured

No

100

Each

56.0000

1

1

D2674-3

Nut Plate

**

MLJ 15-12-16

Location

Loc Qty

Loc Code

Mezz

56

15110

56

1

D2682-041

Manufactured

No

100

Each

73.0000

1

1

D2682-041

Support Plate, EC 120 Step

**

MLJ 15-12-16

Location

Loc Qty

Loc Code

Mezz

73

15393

40

15738

33

Picklist Print

Monday, December 14, 2015 3:57:58 PM

Page 2

Work Order ID: 139941

139941

Parent Item: D2610-042

D2610-042

Parent Item Name: Step, EC120 Step

Start Date: 12/14/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2683-041

Manufactured No

100

Each

51.0000

1

1

D2683-041

End Plate, EC 120 Step

MLJ 15-12-16

Location

Loc Qty

Loc Code

Mezz

51

15168

15

15506

36

M7885/3-4-4

Purchased

No

100

Each

92.0000

5

5

M7885/3-4-4

Rivets

MLJ 15-12-16

Location

Loc Qty

Loc Code

ST557

2

108077

2

ST567

90

m133694

90

MS20426AD3-5

Purchased

No

100

Each

4,907.000

2

2

MS20426AD3-5

Rivet

MLJ 15-12-16

Location

Loc Qty

Loc Code

GA

4184

4533

4184

ST312

723

4444

723

Picklist Print

Page 3

Monday, December 14, 2015 3:57:58 PM

Work Order ID: 139941

139941

Parent Item: D2610-042

D2610-042

Parent Item Name: Step, EC120 Step

Start Date: 12/14/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

MS24693-C272

Purchased

No

100

Each

1,084.000

2

2

MS24693-C272

Screw

MLJ 15-12-16

Location

Loc Qty

Loc Code

cck007a

986

17137

467

17831

519

ST287

98

9370

98

2

MS27039-1-09

Purchased

No

100

Each

155.0000

2

2

MS27039-1-09

Screw

MLJ 15-12-16

Location

Loc Qty

Loc Code

FP001

34

18057

34

GA

36

124859

36

ST0285

45

125646

45

2

ST285

40

124859

29

m130388

11

Picklist Print

Monday, December 14, 2015 3:57:59 PM

Page 4

Work Order ID: 139941

139941

Parent Item: D2610-042

D2610-042

Parent Item Name: Step, EC120 Step

Start Date: 12/14/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

100

Each

1,785.000

2

2

NAS1149D0332.J

Washer

MCS 15-12-16

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

72

m129682

72

GA

327

m132677

327

ST264

1372

m133498

1372

D2622-120C

Manufactured

No

110

Each

120.0000

1

1

D2622-120C

Step Extrusion

CPL 15-12-16

Location

Loc Qty

Loc Code

WA003

120

130161

5

134783

115



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>KE</i>	DRAWING NO. D2610	REV. E SHEET 1 OF 2
DATE 97.09.18		TITLE EC120 STEP ASSEMBLY	SCALE NTS
A	96.10.22	ORIGINAL ISSUE	
B	97.01.14	HAND DRAWING	
C	97.05.09	REVISED MOUNTING LUGS	
D	97.06.04	REVISED FWD END OF STEP	
E	97.09.18	ADDED NUT PLATE	

RELEASED
970125 KE
TSR A450

EFFECTIVE

DEOs

9083	

Qty -041	Qty -042	Part Number	Description
X		D2610-041	STEP ASSEMBLY LH
	X	D2610-042	STEP ASSEMBLY RH
1	1	D2674-3	NUT PLATE
1		D2678-041	STEP WELDMENT LH
	1	D2678-042	STEP WELDMENT RH
1	1	D2682-041	SUPPORT PLATE
1	1	D2683-041	END PLATE
2	2	AN960JD10L	WASHER
2	2	MS20426AD3-5	RIVET
2	2	MS24693-S272*	SCREW
2	2	MS27039-1-09	SCREW
5	5	M7885/3-4- 8 4	RIVET (OR CR3212-4- 8 4)

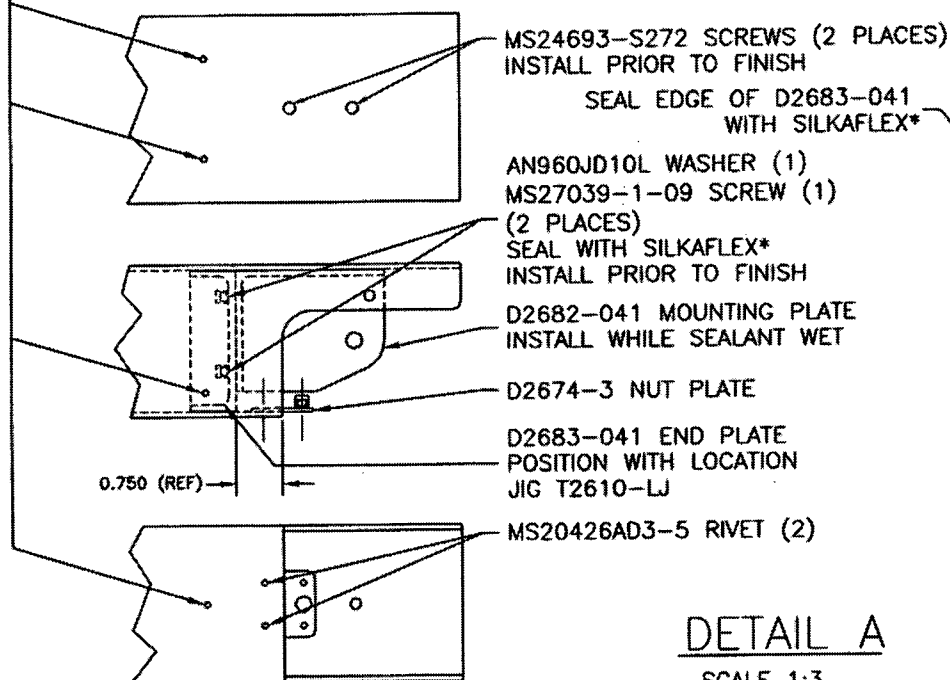
TSR 1341

00.10.12
CP 00.10.12

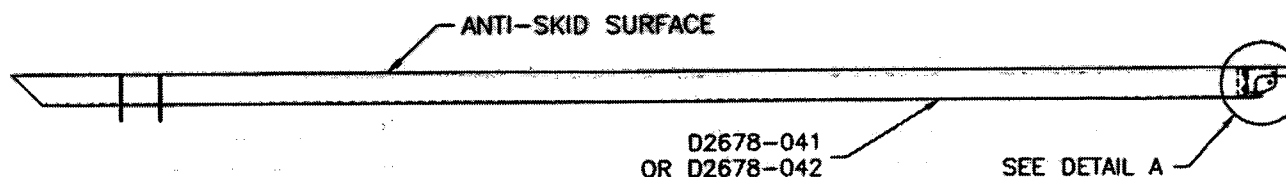
*MS24693-C272 SCREWS MAY BE SUBSTITUTED FOR MS24693-S272 SCREWS

DEO's	9083	97/10/02 KE							
-------	------	-------------	--	--	--	--	--	--	--

Ø0.128 TRANSFER HOLES FROM STEP
C'SINK Ø0.216 x 100"
M7885/3-4-4 (CR3212-4-4) RIVET (5) *# 00.10.12*
(TOUCH UP WITH ZINC CHROMATE PRIMER PER QSI 005 4.2) *UP 00.10.12*



DETAIL A
SCALE 1:3



D2610-041 SHOWN (L.H.) (USE D2678-041 WELDMENT)
D2610-042 OPPOSITE (R.H.) (USE D2678-042 WELDMENT)

- FINISH: - PRIME PER QSI 005 4.2
OR
- POWDER COAT ASSEMBLY TO CUSTOMER SPEC AS PER QSI 005 4.3
- ANTI-SKID TOP PER QSI 005 4.4 (MASK TO BOTTOM OF RADIUS)
OR
- PAINT ASSEMBLY TO CUSTOMER SPEC AS PER QSI 005 4.2.
- ANTI-SKID TOP PER QSI 005 4.4 (MASK TO BOTTOM OF RADIUS)

*NOTE: SILKAFLEX-241 ADHESIVE
PER MANUFACTURER'S SPECIFICATION
POSSIBLE VENDOR: PAYNE'S MARINE SUPPLY

RELEASED
470925 KE
TSR A450

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>WV</i>	APPROVED <i>KE</i>	DRAWING NO. D2610	REV. E
DATE 97.09.18		TITLE EC120 STEP ASSEMBLY	SHEET 2 OF 2
			SCALE 1:15



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2678	REV. B SHEET 1 OF 4
DATE 97.09.17		TITLE EC120 STEP WELDMENT	SCALE NTS
A	96.10.22	NEW ISSUE	
B	97.09.17	CHANGE LENGTH AND HOLE PATTERN	

RELEASED
970425 KB
TSR 4450

Qty -041	Qty -042	Part Number	Description
X		D2678-041	STEP WELDMENT LH
	X	D2678-042	STEP WELDMENT RH
2	2	D2613	LUG
1	1	D2622	EXTRUSION (CUT PER DWG)
1	1	D2669-45	END PLATE

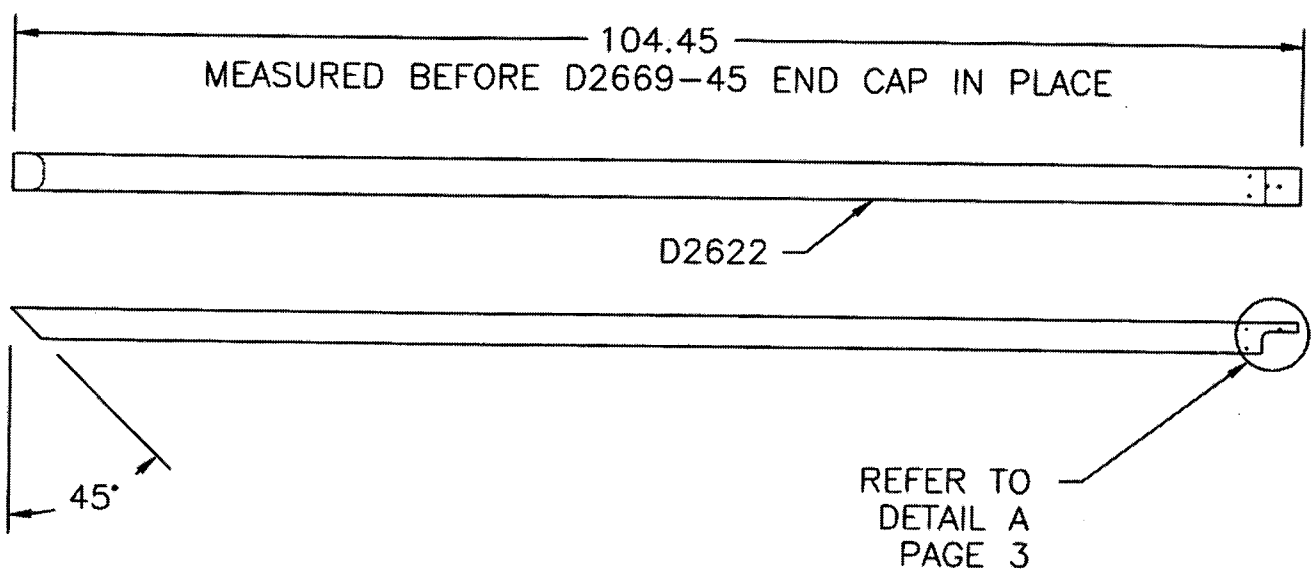
EFFECTIVE	DEOs
9/06	
9/21	

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139941



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>WV</i>	APPROVED <i>WV</i>	DRAWING NO. D2678	REV. B
DATE 97.09.17		TITLE EC120 STEP WELDMENT	SHEET 2 OF 4
			SCALE 1:1.5

RELEASED
970925 KE
TSR A450

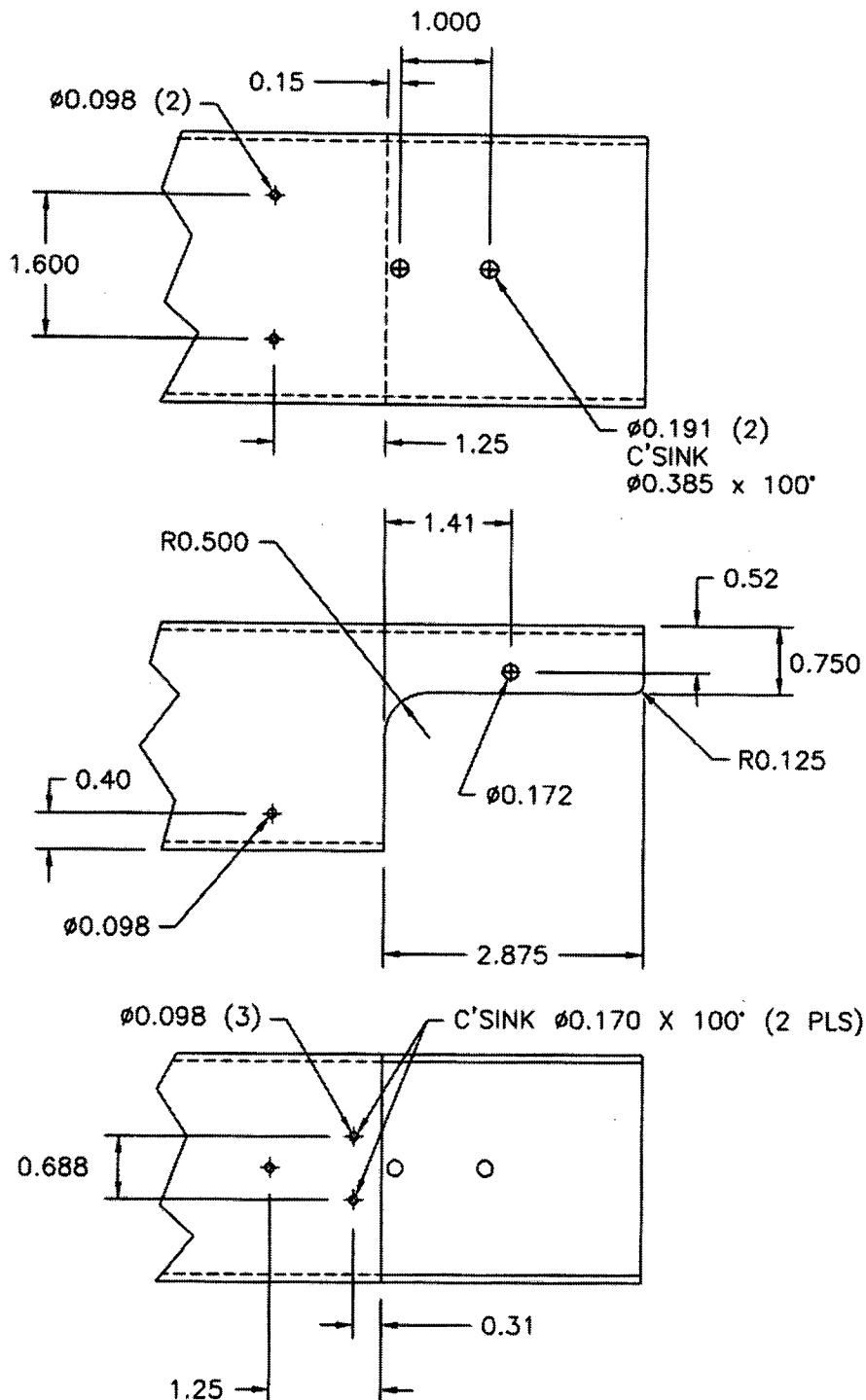
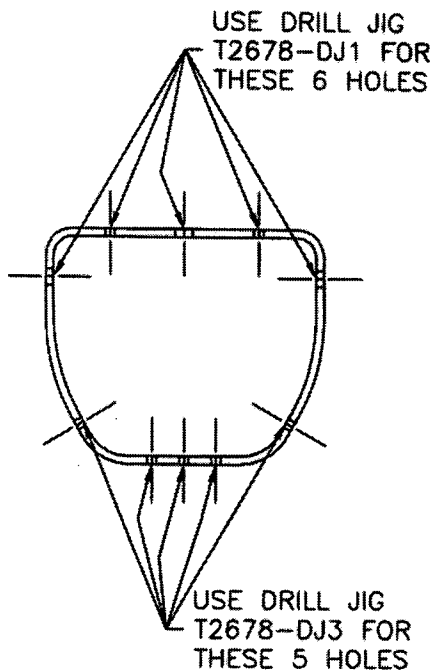


MATERIAL: MAKE FROM D2622 EXTRUSION
FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2678	REV. 8
DATE 97.09.17		TITLE EC120 STEP WELDMENT	SHEET 3 OF 4
			SCALE 1:2

RELEASED
970925 KE
ISR A450

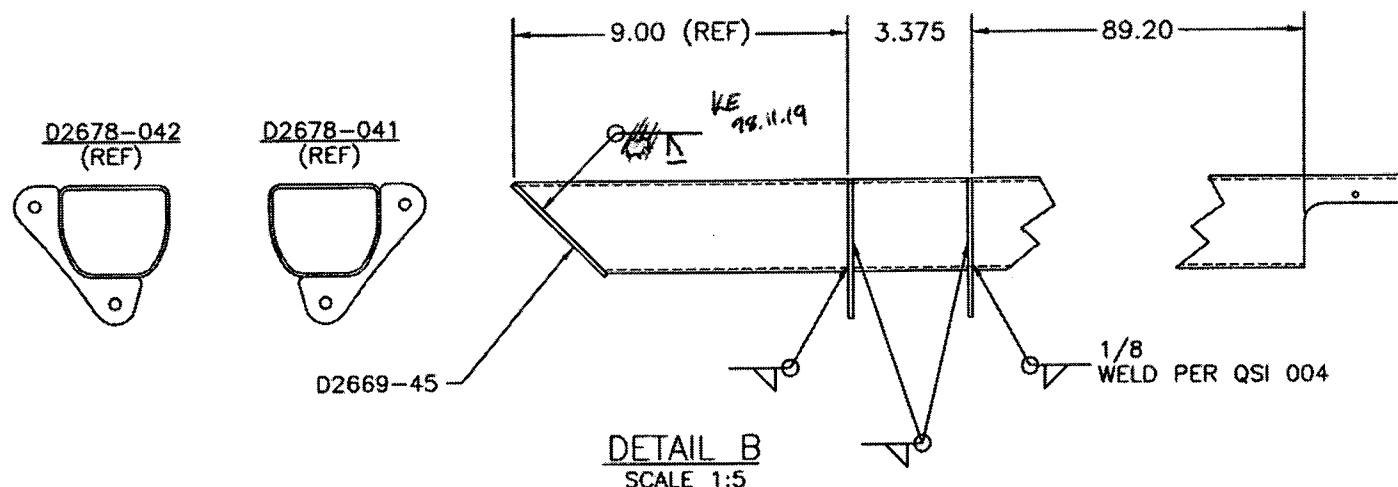
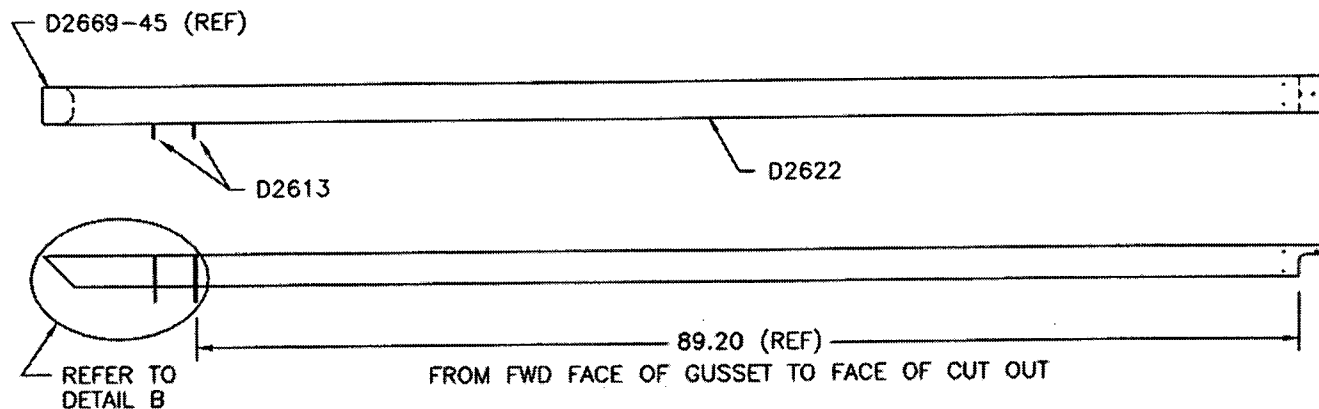


DETAIL A



DESIGN	KE	DRAWN BY	KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	WJ	APPROVED	WJ	
DATE	97.09.17	DRAWING NO.	D2678	REV. B
		TITLE	EC120 STEP WELDMENT	SHEET 4 OF 4
				SCALE 1:15

RELEASED
470925 KE
TSR A450



D2678-041 SHOWN (L.H.)
D2678-042 OPPOSITE (R.H.)